

8 c Ae
13.12.16

Work Order ID 109999

Monday, December 16, 2013 11:37:49 AM

109999

Page 3

Item ID: D3512-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stainless Steel Wearplate

Start Date: 12/16/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/20/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: W2001

0.00

150

Packaging

Memo

0.00

Packaging

(8)31213.12.16

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/12/18 dfplb-b-18

Picklist Print

Monday, December 16, 2013 11:37:49 AM

Page 1

Work Order ID: 109999

Parent Item: D3512-1

Parent Item Name: Stainless Steel Wearplate

Start Date: 12/16/2013

Required Date: 12/20/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD
REV.D DWG DD VERF:JLM

IPP REV:D 13.12.11 ECN13-619/

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA		Purchased	No				sf	210.6540		3			
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304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	210.6539998	
123136	140.2	
M126159	25.94	
<u>M126915</u>	44.514	

Ac 13.12.16

126915 → (3)

DART AEROSPACE LTD		Work Order:	109999
Description: Wearplate		Part Number:	D3512-1
Inspection Dwg: D3512 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

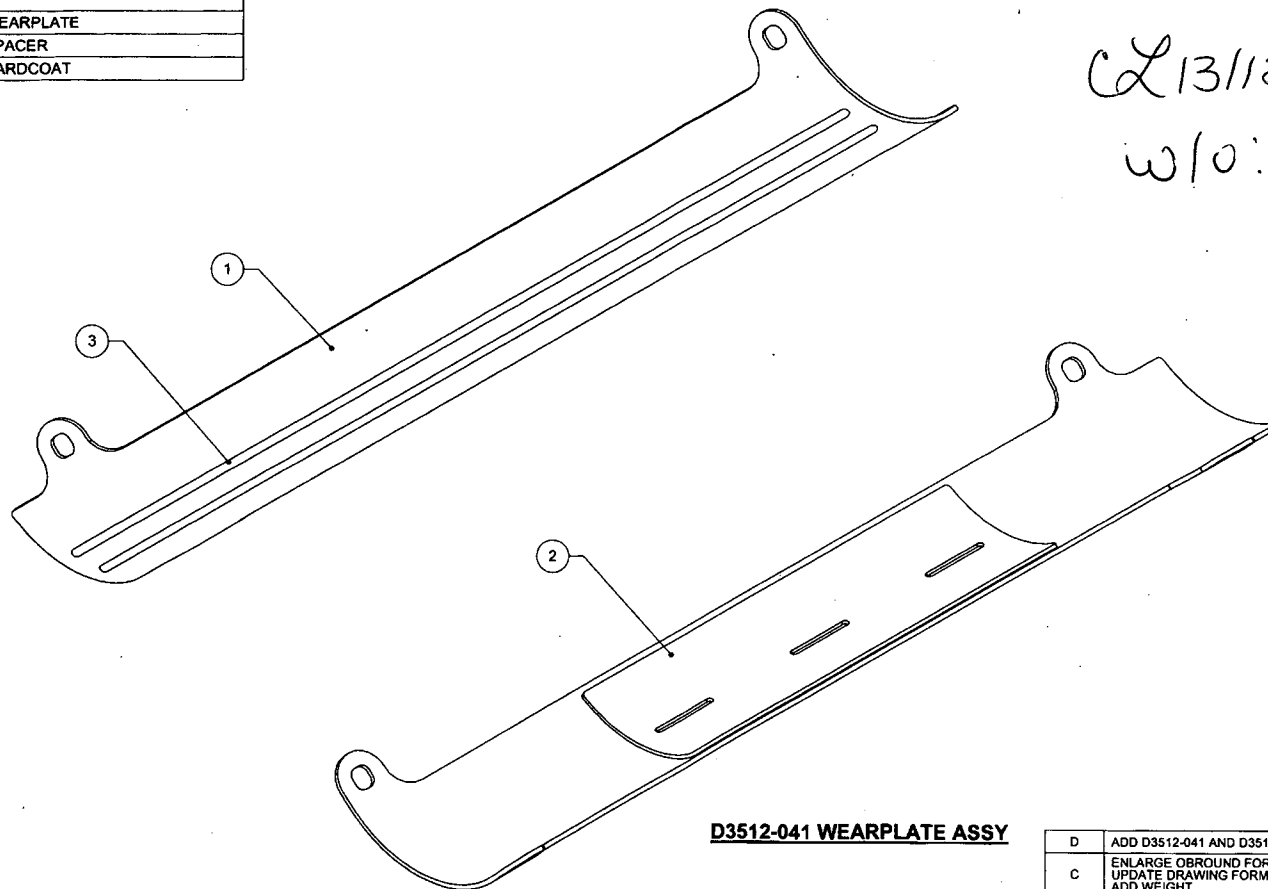
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010					
12.600	+/-0.010					
0.145	+/-0.010					
0.750	+/-0.010					
2.631	+/-0.010					
2.341	+/-0.010					
1.240	+/-0.010	1.24	-		V	Jkm-05
0.220	+/-0.010					
0.380	+/-0.010					
0.063	+/-0.010	.062	-		V	
3.84	+/- .030					
3.84	+/- .030	3.83	-		V	
2.34	+/- .030	2.34	-		V	
12.605	+/- .010	12.605	-		T	Jkm-06
14.22	+/- .030	14.22	-		T	
3.140	+/- .010	3.140	-		V	
300 x .300	+/- .010	300 x .300	-		V	

* Actual Measurements *
* From Drawing *

Measured by: Ae	Audited by: DAS 27	Prototype Approval:	N/A
Date: 13.12.16	Date: 13/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT

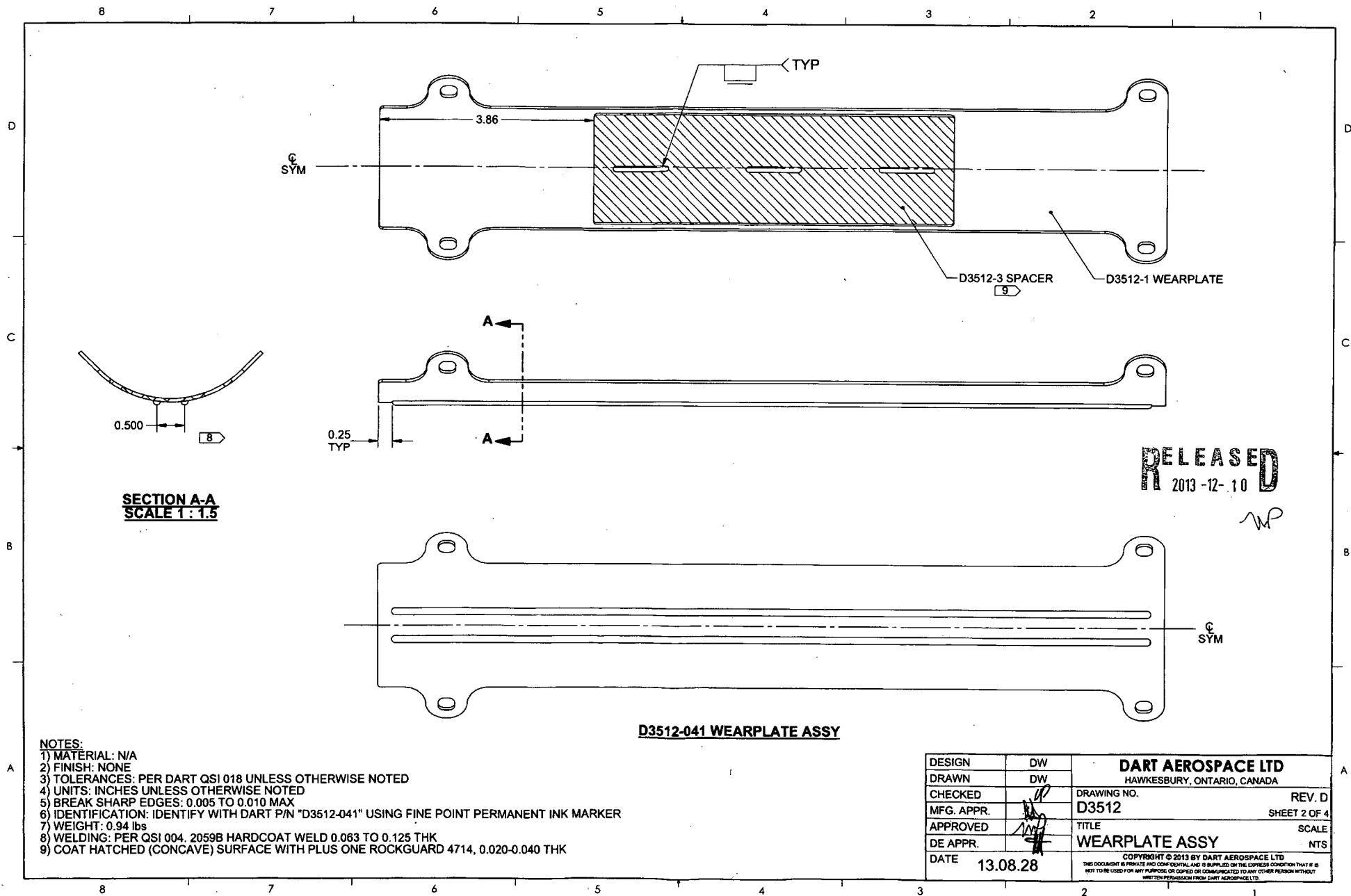


CL13/12/16
w/o: 109999

RELEASED
2013-12-10
wp

D3512-041 WEARPLATE ASSY

D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3512	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	NTS
DATE	13.08.28	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

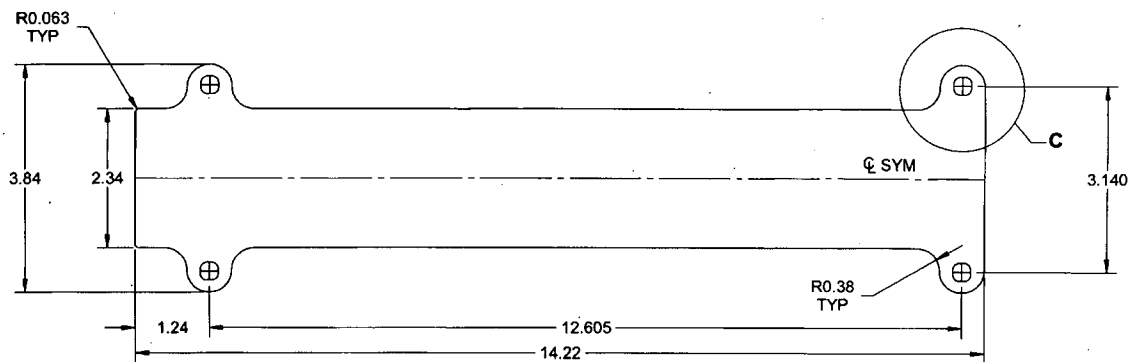
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

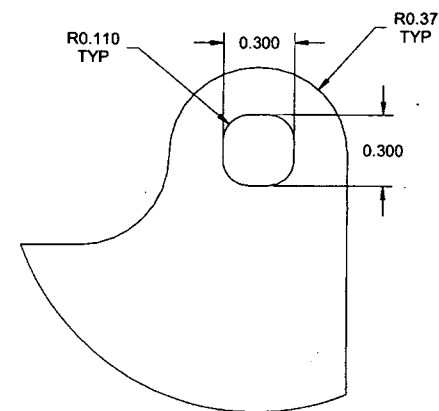
D

C

B



D3512-1F



DETAIL C
SCALE 2X

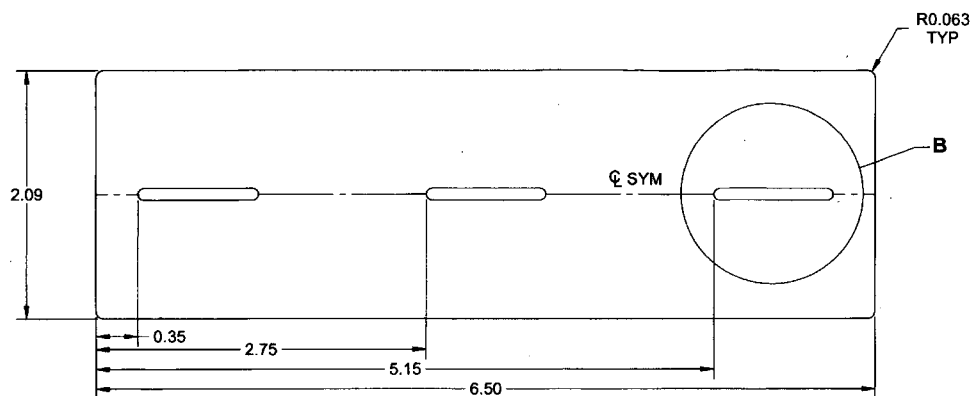
RELEASED
2013-12-10
WP

NOTES:

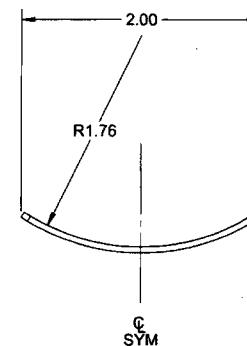
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WP	DRAWING NO.	REV. D
MFG. APPR.	WP	D3512	SHEET 3 OF 4
APPROVED	WP	TITLE	SCALE
DE APPR.	WP	WEARPLATE ASSY	NTS
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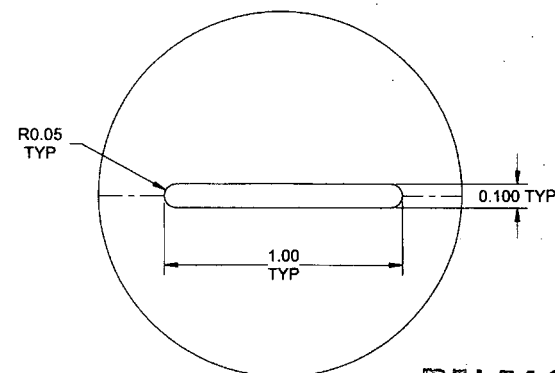
8 7 6 5 4 3 2 1



D3512-3F FLAT PATTERN



**D3512-3 SPACER
MAKE FROM D3512-3F**



**DETAIL B
SCALE 2X**

RELEASED
2013-12-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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